

Date: Wednesday, 5/23/2007 3:24:23 PM  
User: Kim Johnston

## Process Sheet

SPLIT-

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PLUG		
Job Number	: 32466						
Estimate Number	: 10512						
P.O. Number	: N/A			Part Number	: D26511		
This Issue	: 5/23/2007	S.O. No.	: HLA	Drawing Number	: D2651 REV. B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A			Drawing Revision	: B		
Previous Run	: 32118			Material	: N/A		
Written By				Due Date	: 6/6/2007		
Checked & Approved By				Qty:	200		Um: Each
Comment	Est:	A	02.04.15	New Issue	NG		
	Est:	B	05.12.12	added deburr	EC		

#### **Additional Product**

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500 	6061-T6 Round Bar .500" 
	Comment: Qty.: 0.0421 f(s)/Unit Total : 8.4210 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: M104619 87" [7.25]	RQ 07/06/20
2.0	HARDINGE 	HARDINGE CNC LATHE SMALL 
	Comment: HAAS CNC VERTICAL MACHINING #1 Hardinge CNC lathe 1- Turn as per Folio FA219 and Dwg D2651  2- Deburr	RQ, MS 07/06/20
3.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE  X220
4.0	QC8 	SECOND CHECK 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	RQ, MS 07/06/20
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651	ml 07/6/26 X220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 010204  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32466		Part Number: D26511
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 44K <i>m.f. 07/06/27</i>
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	POWDER COATING 	POWDER COATING <i>SPRAY POWDER Delfleet Blue + clear</i> Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 (Only larger section necessary) <i>Issue P.O 4053 06/06/27(4) Atelier de brossage 44</i>
8.0	QC14 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>QC14 06-07-03 counted 45</i>
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 45
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>Finshtank</i> 07/17/4 (45)		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE 45 <i>07/17/4 (45) 07/17/04</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion  <i>W 07/17/04</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32466
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>RD</i>	Audited by:	<i>MS</i>	Prototype Approval:	N/A
Date:	<i>07/06/20</i>	Date:	<i>07/06/20</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF 	



**DART**

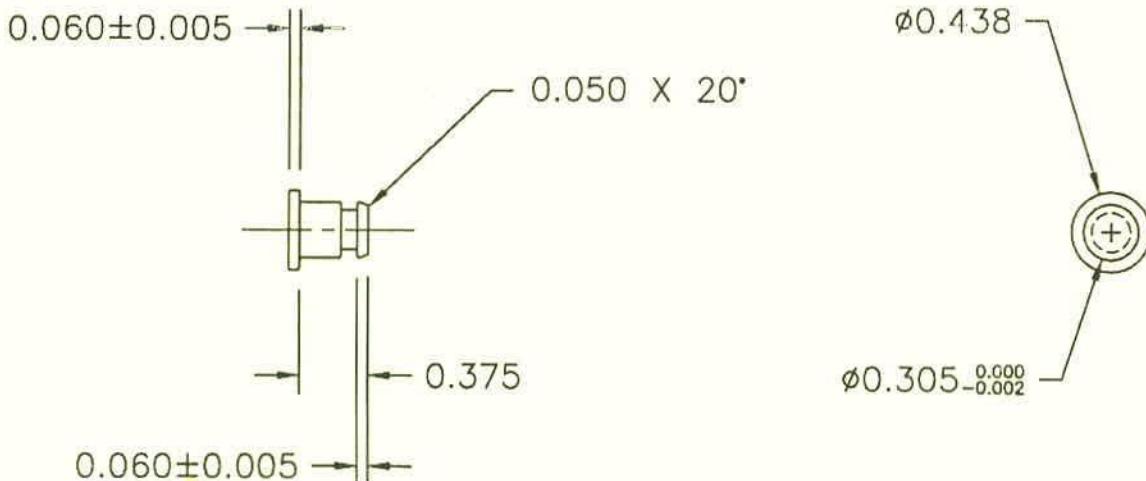


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

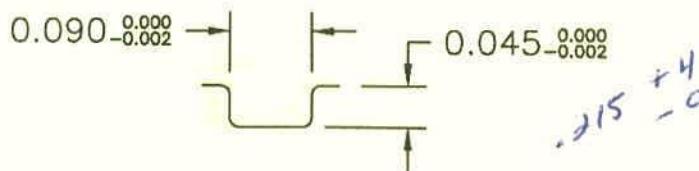
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32466

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